

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025119**Date Inspected:** 06-Jul-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	CWI Present:	Yes	No			
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006	Component:	Orthotropic Box Girder(OBG)				

Summary of Items Observed:

On this day CALTRANS OSM Quality Assurance (QA) Inspector Manoj Prabhune was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector randomly observed the following work in progress:

Blast Shop – 2

14 West

This QA Inspector performed Blast inspection on base metal, fillet welds and complete joint penetration (CJP) welds from panel point (PP) 125 to PP126 on internal surface of vertical plate, side panel, edge panel and bottom panel, Bottom plate T-rib, Side plate I-rib Following points were noted today morning after Blast Inspection of 14 West:

-At PP 125 cable side, deep gouge surfaces at three (3) location observed on BP 3088A in between 5th and 6th vertical shear plate from W3 location.

-Near PP 126 cable side, deep gouge surfaces at three (3) location observed on BP 3088A in between 6th and 7th vertical shear plate from W3 location.

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-At PP 125 (E) cable side, incomplete welding observed on weld joint SEG3020T-063 at cope hole area in between 6th to 7th vertical shear plate from W3 location.

-At PP 125.5 (E) weld joint (CJP with steel backing) joining web plate of FB 3318B to LD 3048A, the gap between steel backing bar and web plate is observed

At PP 125.5 (E) weld joint (CJP with steel backing) joining web plate of FB 3318B to LD 3048A, the backing bar was observed as tack welded.

All information regarding this marked on weld map and submitted to Lead QA Inspector.

NDT:

Segment 13AE

This QA Inspector performed Magnetic Particle Testing (MPT) Verification Inspection of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report on this date. The members are identified as Orthotropic Box Girder (OBG) components. The weld designations Verified are as follows.

LD3028-052, 053, 076, 077, 100, 101, 124, 125, 148, 149, 172, 173, 196, 197, 220, 221, 238, 239

Unless otherwise noted, all work observed on this date appeared to generally comply with the applicable contract documents.

Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey - 15000026784, who represents the Office of Structural Materials for your project.

Inspected By:	Prabhune,Manoj	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer
